

Date: Tuesday, 12/05/2009 11:36:26 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L BASKET BASE		
Job Number	: 45544A		Part Number	: D2252041		
Estimate Number	: 11273		Drawing Number	: D2252 REV.G		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/05/2009	S.O. No. :	Drawing Revision	: G		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : LARGE FAB ASSY	Due Date	: 22/05/2009 Qty: 1 Um: Each		
Previous Run	: 47904A					
Written By	:					
Checked & Approved By	: JWD 09.05.09					
Comment	: Est Rev:I Revised as per Rev E 05-12-06 JLM Est Rev:J 08-09-09 revF as per dwg (ecn 08-522) DD verified by:EC Esr Rev K 09.03.18 Rev.G dwg ecn 09.532 EC verified by:DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
		N/A
		Comment: Qty.: 25.0000 f(s)/Unit Total: 25.0000 f(s) 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: N/A
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		N/A
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Cut 5 D2235-1 From D3106-1 2- Cut Ribs as per Dwg D2252 3-Drill hole in D2252-1as per Dwg D2252
		4-Deburr & Remove all Markings from Material PD 09-05-13
3.0	D22211	Rib
		D2989-17
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Rib B45938 → 1 use B43994 → 1 PD 09-05-13
4.0	D22351	Basket Rib
		N/A
		Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s) Basket Rib B46823 → 4 B46771 → 1 PD 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 45544A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22521 Frame



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Frame B46824

PD 09-05-13

6.0 D22529 Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Frame B46830

PD 09-05-13

7.0 D225211 Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Frame B46821

PD 09-05-13

8.0 D225213 Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Frame B46825

PD 09-05-13

9.0 D225215 Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Frame B46826

PD 09-05-13

10.0 D225217 Frame



P7C

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Frame B47841

PD 09-05-13

11.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253-1	Gusset	B40894

PD 09-05-13

12.0 D2254 Gussett



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	B39801		

PD 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2252-041 PAR #: N/A Fault Category: Prod/Fab. Lrg. NCR: Yes No DQA: Date: 05/06/02
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: Date: 05/06/02

NCR: 45544 A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-05-13	10.0	- Qty 4 parts scrap. Parts were supposed to be 53° on both sides, and were cut & inspected with 50° on one end & 45° on the other. <u>Qty 4 D2252-17 B46827 L. A.</u>	J DSMR	- Scrap & destroy. cannot be used for any other parts. Will be too short. Replacement will be made on known bad w/o.	GMS JL 09-05-22 DSMR	PD 09-05-22	05/04/13	09-05-13

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 45544A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

2 D2254 Lug B39801

PD 09-05-13

13.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2327-3 Bushing B44365

PD 09-05-13

14.0 D2581 Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D2581 Mounting Chanel B416086

PD 09-05-13

15.0 D37481 Hinge Half



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Hinge Half B45605 → 2 B34689

PD 09-05-13

16.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch
32 sf M304EX0.75-16F Expanded Metal M111630

S101 09-05-18

17.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M108160

PD 09-05-21

18.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CJ 09-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 45544A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S09/05/09 (1)

20.0 POWDER COATING

POWDER COATING



M111472
PRESSURE WASH BK 09-05-09 (1)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST START TIME:

7:15AM

2ND START TIME

8:00AM

OVEN TEMPERATURE: 400°F

OVEN TEMP: 400°F

FINISH TIME: 7:45AM

FINISH TIME 8:30AM

09-05-26 X(1)

21.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

WMO/SLK 09/05/09 (1)

22.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PM 45544 R 9/05/09 (1)

23.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/09 (1)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

G

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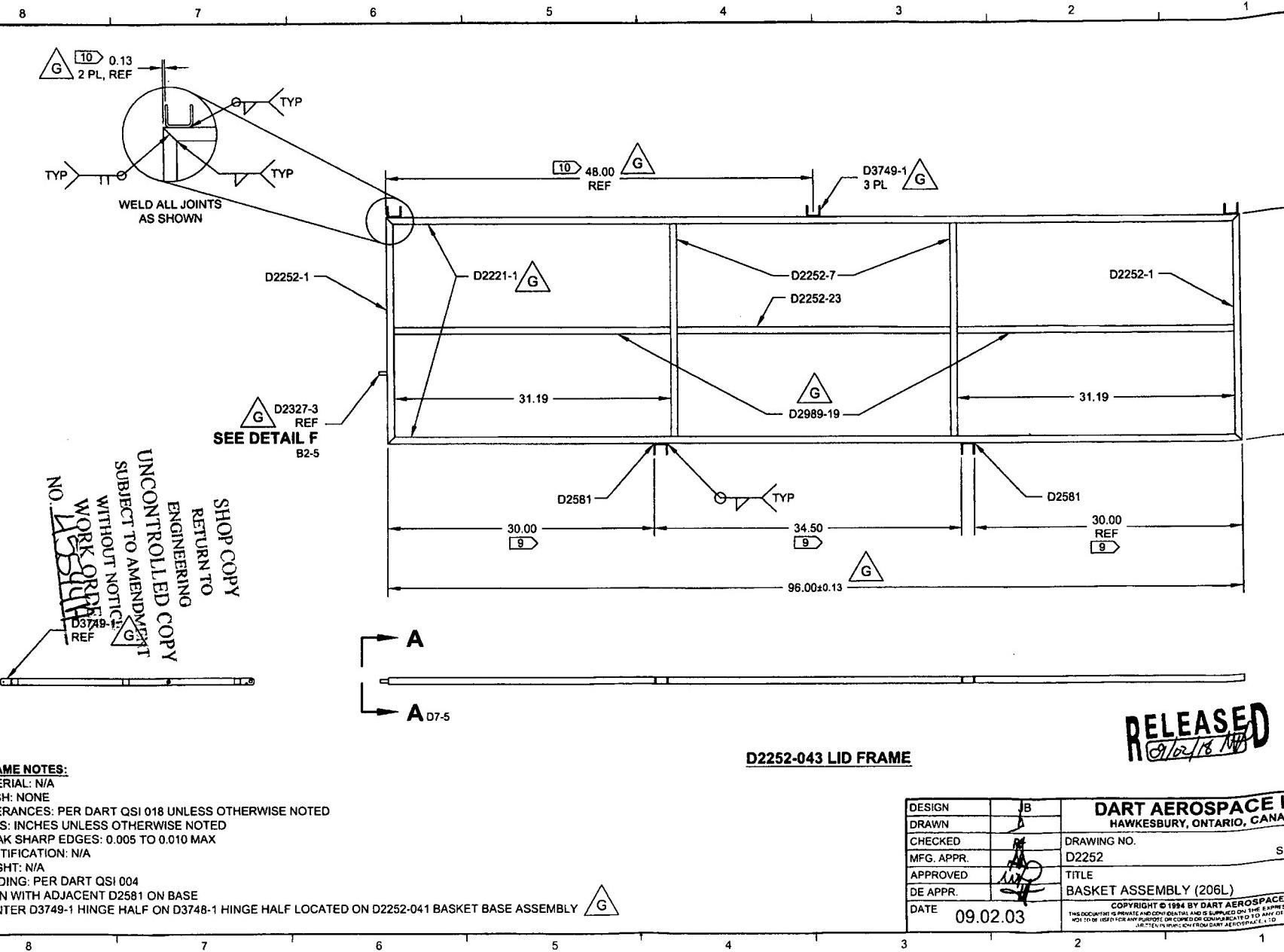
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 55544

- NOTES:**
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
 - 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: N/A
 - 9) WELDING: PER DART QSI 004

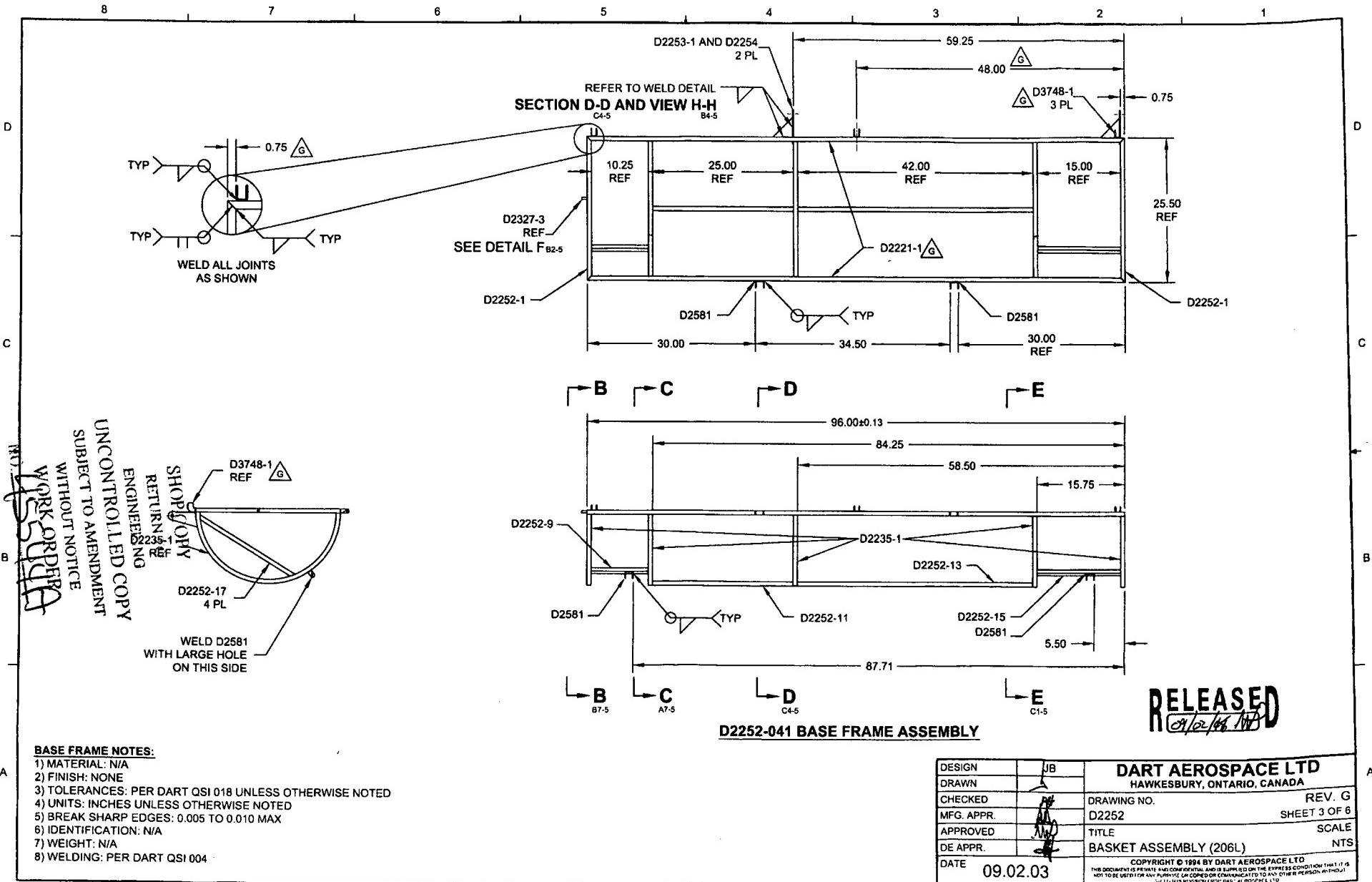
RELEASED
07/07/18

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19, ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#009-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA	
DRAWN		REV. G	
CHECKED		DRAWING NO.	
MFG. APPR.	D2252	SHEET 1 OF 6	
APPROVED		SCALE	
DE APPR.		NTS	
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DESIGN	JB	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. G
MFG. APPR.		SHEET 2 OF 6
APPROVED		D2252
DE APPR.		SCALE
DATE 09.02.03		TITLE NTS
		BASKET ASSEMBLY (206L)

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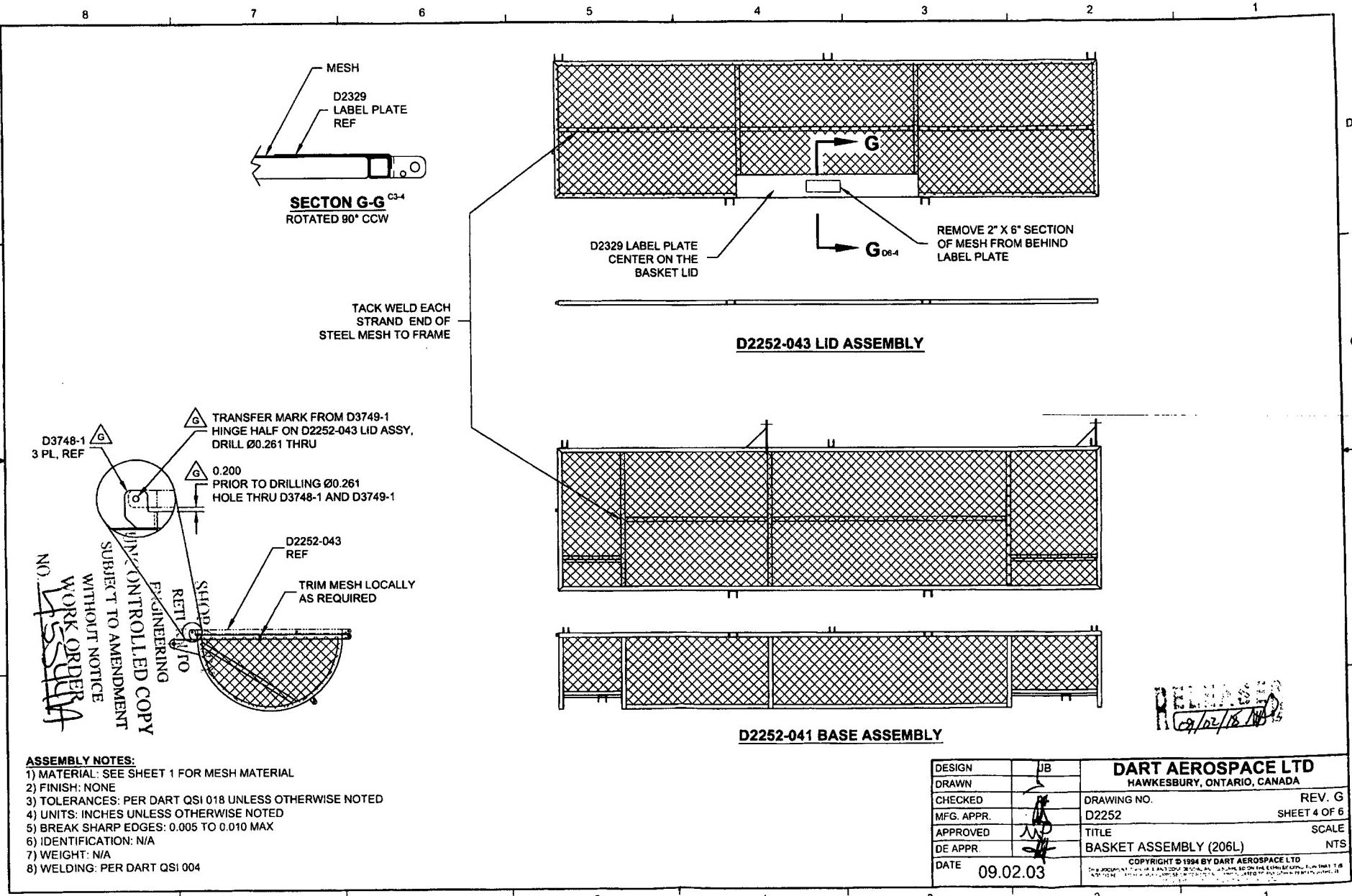


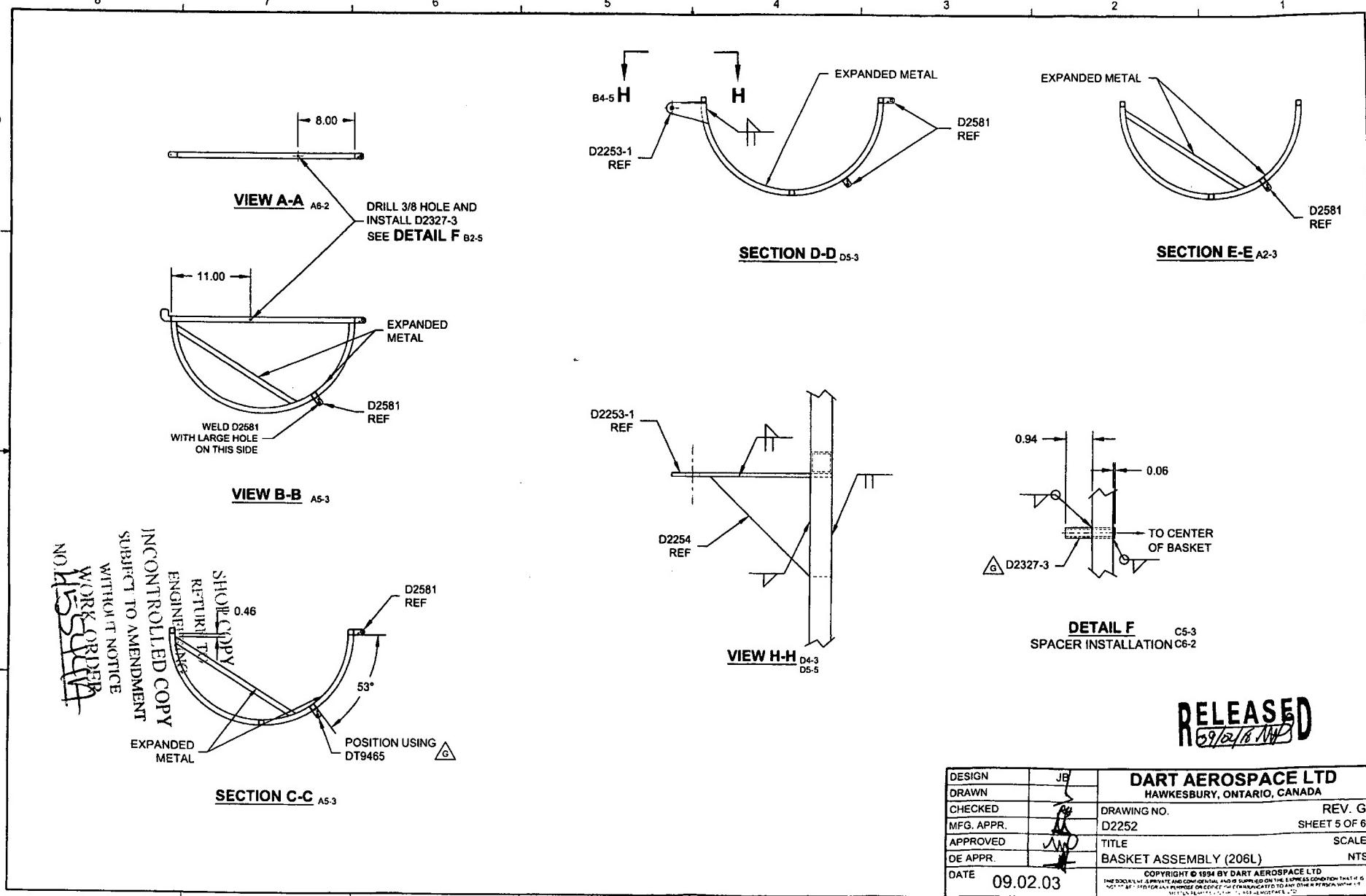
BASE FRAME NOTES:

- MANUFACTURER NOTES:

 - 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
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MFG. APPR.	AB	D2252	SHEET 3 OF 6	
APPROVED	AB	TITLE	SCALE	
DE APPR.		BASKET ASSEMBLY (206L)	NTS	
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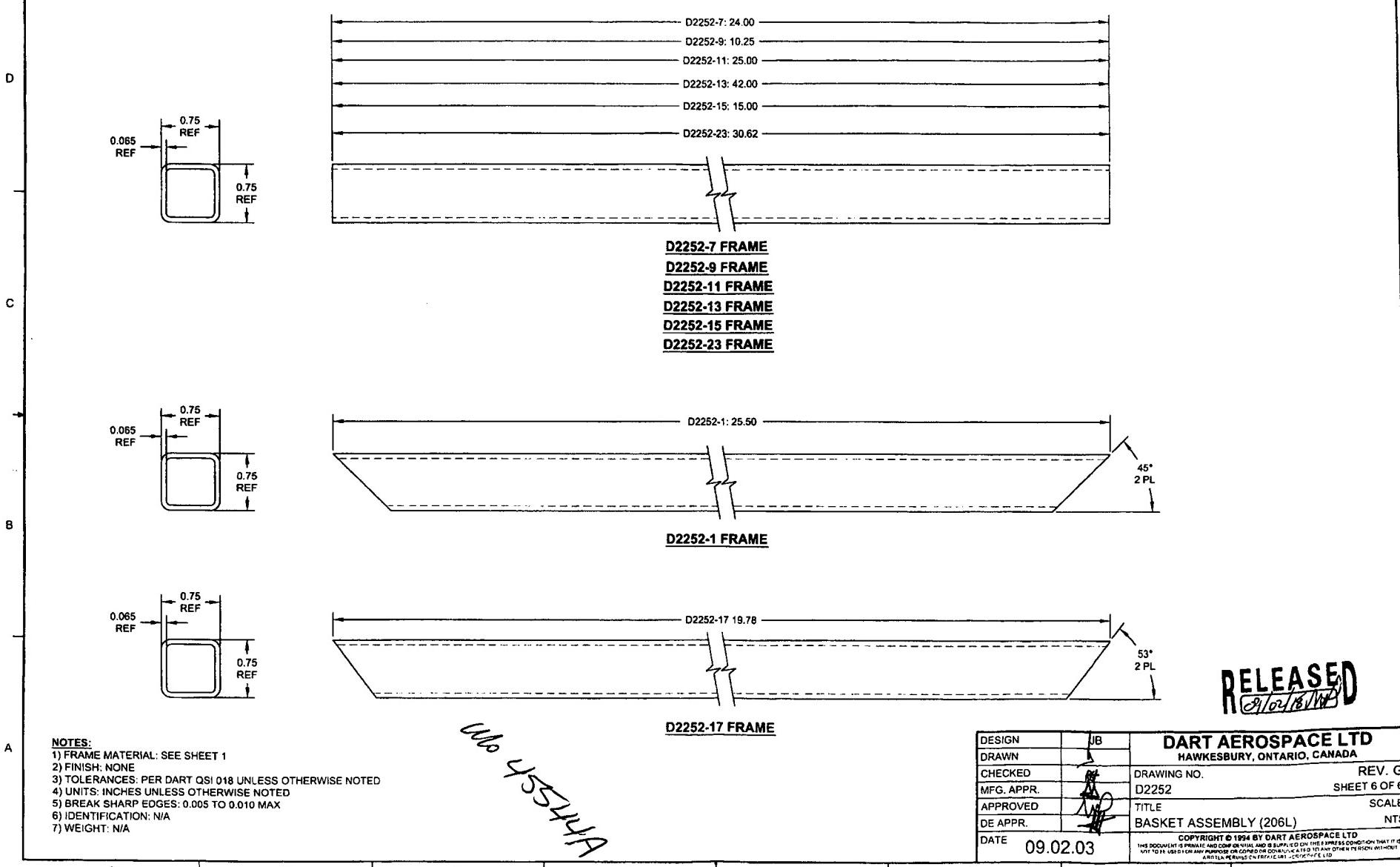


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CHECKED		DRAWING NO.
MFG. APPR.		D2252
APPROVED	JW	SHEET 5 OF 6
DE APPR.		TITLE
DATE	09.02.03	SCALE
		NTS

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09/02/03 MP

8 7 6 5 4 3 2 1



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MFG. APPR.		D2252
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8/02/03/MW